

Date: Friday, 10/13/2006 9:27:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 28959	
Estimate Number : 11627	
P.O. Number :	Part Number : D2965
This Issue : 10/13/2006 S.O. No. :	Drawing Number : D2965 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : PURCHASED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By : <u>JA 06 10 13</u>	Due Date : 11/5/2006 Qty: <u>30</u> Um: <u>U</u> Each
Checked & Approved By :	
Comment : Est: A 00:08:31 New Issue EC	

Additional Product

15 taken after seq. 50 to do
2965-3 w/o 29993

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 230606/10/23

Cast per Dwg D2965

Material Release Note Required

2.0	D2965P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Cap

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

LB 06/11/27170

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2965 with DT8538

Deburr and Tumble

SAD 06/12/1430

5.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

JA 06/12/2030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/02	3.1	QC 6 Dimensional Check	AS	06/12/02	30		AS 06/12/02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/08
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:27:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 28959

Part Number: D2965

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref. 4.3.5.7) as per QSI 005 4.3

FL/a.m 07/01/04 (15)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 07/01/04 (15)

8.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M19393

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

a.m 07/01/04 (15)

9.0

SMALL FAB 1

HAND Finishing

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2965

a.m 07/01/04 (15)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 07/01/04 (15)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP

a.m 07/01/04 (15)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.01.05

Job Completion



u 07.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

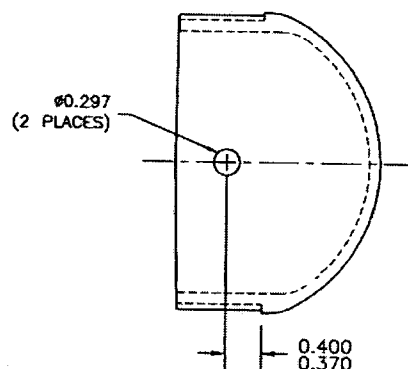
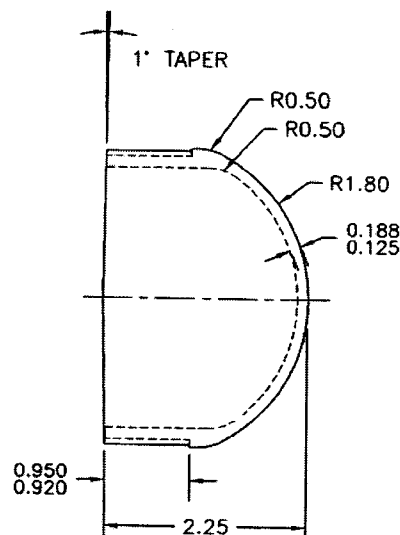
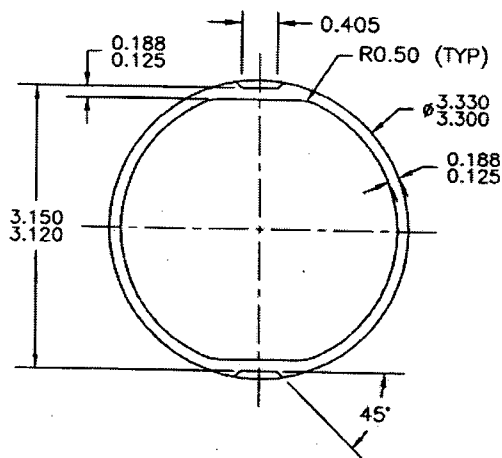
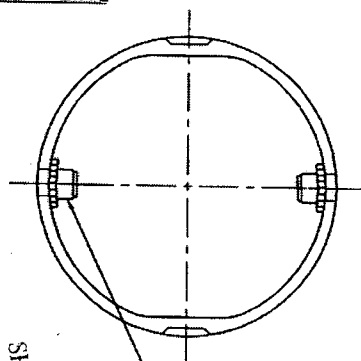
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
KT	KT	BELLEUE, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KT	KT	D2965	
DATE	TITLE	SCALE	
00.02.24	CAP	1:2	
A	00.02.24	NEW ISSUE	
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	

RELEASED
00.05.11**D2965 CASTING DETAIL****D2965 FINISH DETAIL**

INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

BLACK SANDTEX (REF. 4.3.5.7) * 01.01.29
UP 01.01.30

MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 289159

EXPÉDIÉ À - SHIPPED TO

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped

DART AEROSPACE

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Date: 23/11/2006 Packing Slip No. 6423

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 2306
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en fillere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
30	D 2965 CAP	Z200080	A356.2	B#0632601 Ingot #815663 11/06/12/02
Analyse Analysis (as in Ingot)				
(Si)	7.00%	(Al)	balance	
(Fe)	0.08%			
(Cu)	<0.01%			
(Mn)	<0.01%			
(Mg)	0.44%			
(Zn)	<0.01%			
(Ti)	0.16%			
Donne Yield :	Résistance a la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %		

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100